

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010547**Date Inspected:** 29-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 6AE/6BE

This QA Inspector observed grinding in progress of the weld profile on the Side Plate Complete Joint Penetration (CJP) weld, bike path side.

Segment 2W

This QA Inspector observed grit blasting in progress on the interior of the segments.

Segment 6AE

This QA Inspector observed deburring of drilled bolt holes in the Bottom Plate WT stiffener flange along the 5CE/6AE splice location.

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This QA Inspector observed heat straightening on the Side Plate WT stiffeners at panel point 37 following HSR1 (B)-7840.

Segment 1E

This QA Inspector observed grit blasting in progress on the interior of the segment.

Segment 6AE/6BE

This QA Inspector observed cutting of approximately 630mm of the Deck Splice CJP weld approximately 775mm from bike path side Edge Plate for WR8691.

Segment 5AW

This QA Inspector observed match drilling of bolt holes in the Side Plate for the Suspender Bracket, counter weight side.

Segment 5BW

This QA Inspector observed match drilling of bolt holes in the Side Plate for the Suspender Bracket, counter weight side.

Segment 6AW

This QA Inspector observed cutting of the Side Plate to Bottom Plate CJP splice for WR8847, 270mm at the 6AW/5CW location counter weight side. 250mm at the 6AW/5CW location cross beam side.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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| Inspected By: | Hernandez,Dan |
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| Quality Assurance Inspector |
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| Reviewed By: | Miller,Mark |
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| QA Reviewer |
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